

Date: Thursday, 11/01/2007 11:37:22 AM  
User: Linda Lacelle

Process Sheet

SPLIT-2

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARING ASSEMBLY
Job Number	: 30242	Part Number	: D3121241
Estimate Number	: 10716	Drawing Number	: D3121 REV D
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 11/01/2007 S.O. No. : N/A	Drawing Revision	: D
Prsht Rev.	: NC	Material	: N/A
First Issue	: 11/01/2007 Type : MACHINED PARTS	Due Date	: 18/01/2007
Previous Run	: 29829	Qty:	33 Um: Each
Written By	:		
Checked & Approved By	:		
Comment	: Est Rev:A 04.02.18 New issue KJ/DS		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
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1.0	D312125	Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)  
Material: 01.25 Delrin Rod  
(M-DELRIN-R1.2500) Identify as D3121-25  
Batch: B29253

mk 07/01/25 33

2.0	D312123	Bearing
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)  
Pick: B30241 x30  
Qty Part Number Description Batch  
1 D3121-23 Bearing B29727 x30 pieces

no batch number for B30241 \*

mk 07/01/25 33

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press D3121-23 Bearing into D3121-25 Cap as per Dwg D3121

mk 07/01/25 33

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

MS 07/01/25 33

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: 51409

mk 07/01/25 (33) 07/01/24 (23)

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING ASSEMBLY

Job Number: 30242

Part Number: D3121241

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



33

Comment: FINAL INSPECTION/W/O RELEASE

11/01/26

Job Completion

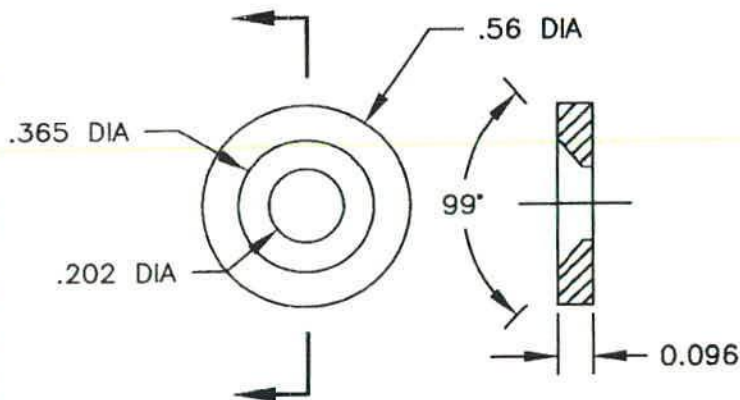


11/01/26

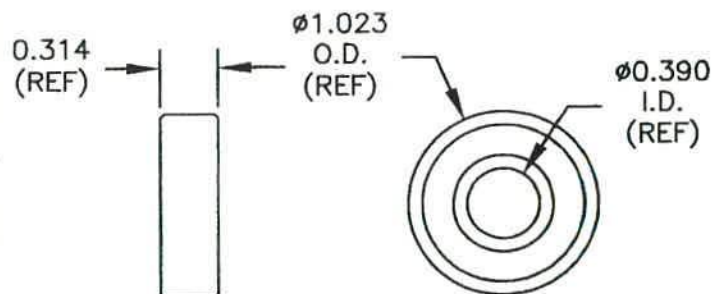


**DART**

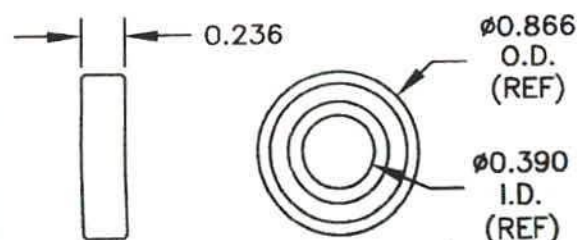
DESIGN	DRAWN BY	DART AEROSPACE LTD	
	C.B.	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. D
		D3121	SHEET 10 OF 10
DATE		TITLE	SCALE
06.05.17		BRACKET ASSEMBLY	1:1

**D3121-17 WASHER (SCALE 2:1)**

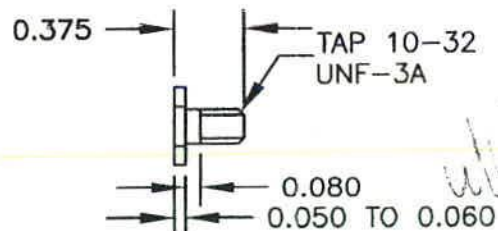
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

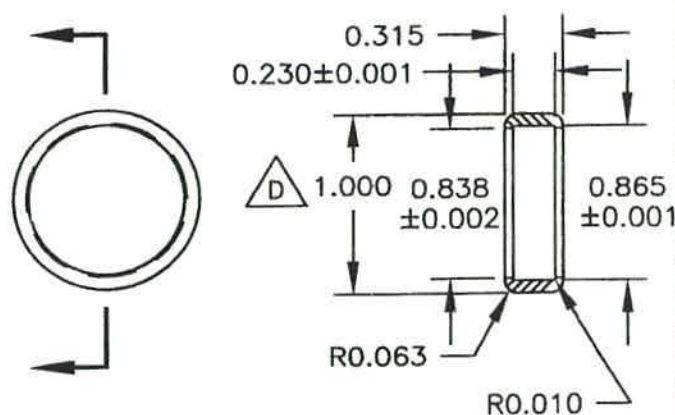
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-2Z
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-21 BOLT (SCALE 1:1)**

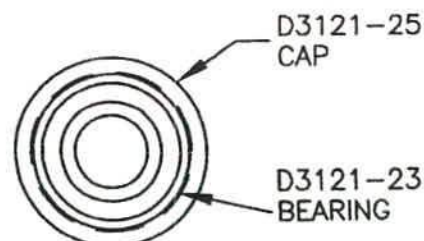
- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, 1.25 (REF DART SPEC. M-DELIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

RELEASED

06-06-02

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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